

5/29

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23626
<b>Description:</b> Bracket Assembly	<b>Part Number:</b>	D2803-042
<b>Dwg:</b> D2803 Rev. B	<b>Qty:</b>	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler <b>Dwg not required</b>	MA	05.06.21	10																				
2	GA	Press D2805-2 into arm as per Dwg D2803 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2803-2</td><td>Bracket</td><td>B23636</td></tr><tr><td>1</td><td>D2805-2</td><td>Stop</td><td>B23637</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>B22529</td></tr></table>	Qty	Part Number	Description	Batch	1	D2803-2	Bracket	B23636	1	D2805-2	Stop	B23637	1	D2809	Bushing	B22529	SAD	05/09/17	10				
Qty	Part Number	Description	Batch																						
1	D2803-2	Bracket	B23636																						
1	D2805-2	Stop	B23637																						
1	D2809	Bushing	B22529																						
3	QC5	Inspect work to Step 2	2	05.09.19	10																				
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	FC	05.09.22	10																				
5	QC3	Inspect Powder Coat	MM	05.09.22	10																				
6	GA	Press D2809 into arm as per Dwg D2803	SB	05/09/26	10																				
7	GA	Spray LPS-3 on Bolt Shaft, <b>not</b> on thread as per Dwg D2803 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN3C16A</td><td>Bolt</td><td>M17944</td></tr><tr><td>2</td><td>MS21043-3</td><td>Nut</td><td>M17239</td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer</td><td>M17944</td></tr><tr><td>A/R</td><td>LPS-3</td><td>Corrosion Spray</td><td>M17395</td></tr></table>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt	M17944	2	MS21043-3	Nut	M17239	4	NAS1515H3	Washer	M17944	A/R	LPS-3	Corrosion Spray	M17395	SB	05/09/26	60
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt	M17944																						
2	MS21043-3	Nut	M17239																						
4	NAS1515H3	Washer	M17944																						
A/R	LPS-3	Corrosion Spray	M17395																						
8	GA	Assemble as per Dwg D2803.	SB	05/09/26	10																				
9	QC5	Inspect work to Step 8	2	05.09.26	10																				
10	ST	Identify and Stock	CL	05/10/05	10																				
11	AC	Cost / part: 121.08	Jur	05-10-06	10																				
12	DC	Close W/O 121.08 Inspect Level 21	17	05/10/06	10																				

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	
F	05.03.30	MS21043-3 was MS21042L3	KJ/JLM	

RELEASED  
05.03.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 20, 2005  
03:23 pm

Work Order No : 0023626  
Project Name : D2803-042  
Project For : WK529  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2803-042  
Description : Bracket Assembly  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 06-20-05  
Est Finish Date : 07-21-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

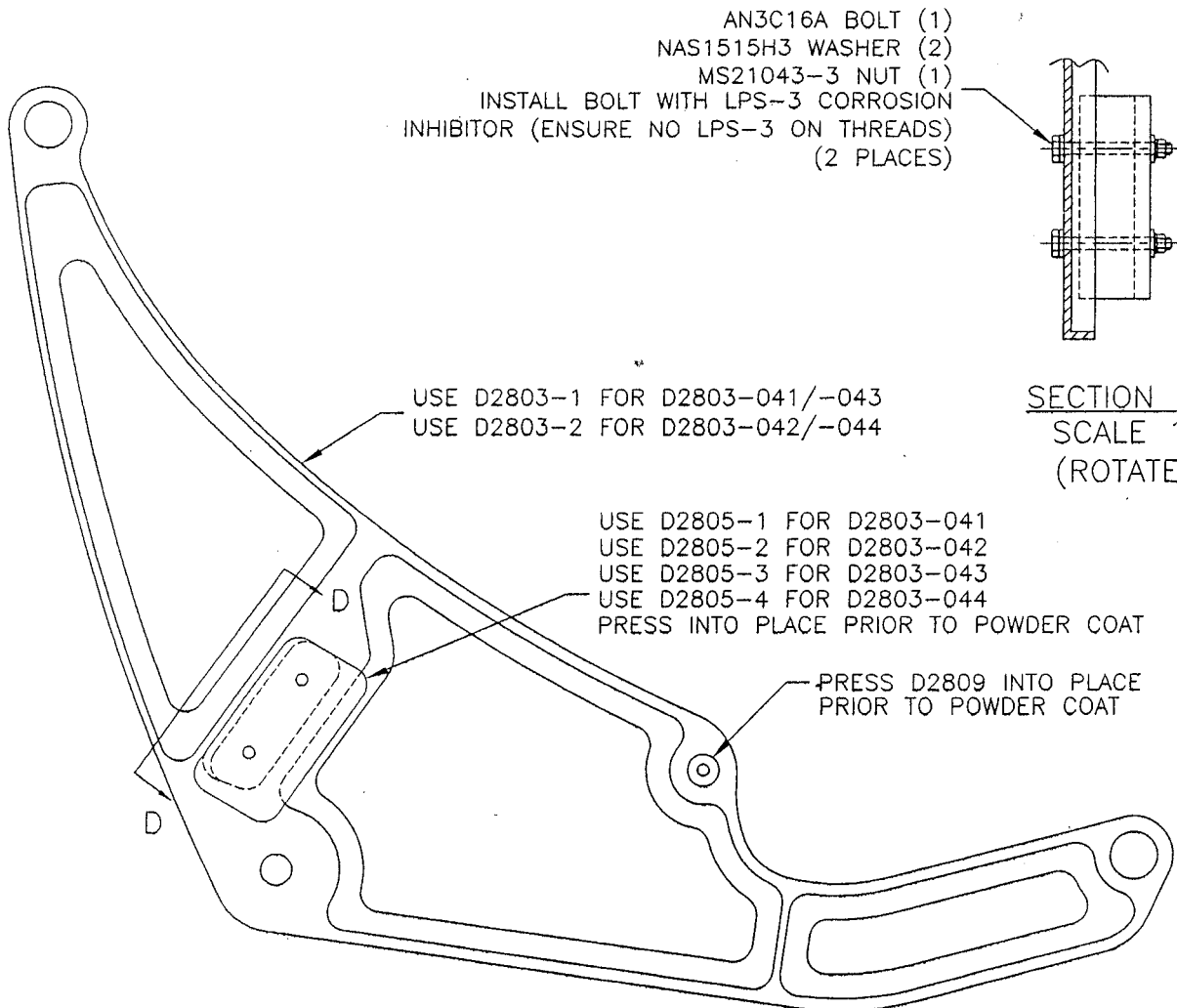
	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

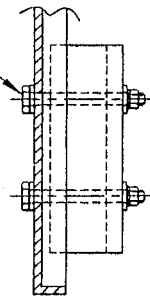
CONTROLLED COPY



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21043-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



SECTION D-D  
SCALE 1:3  
(ROTATED)

USE D2803-1 FOR D2803-041/-043  
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041  
USE D2805-2 FOR D2803-042  
USE D2805-3 FOR D2803-043  
USE D2805-4 FOR D2803-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE  
PRIOR TO POWDER COAT

RELEASED

05-03-11 *[Signature]*

D2803-041/-043 BRACKET ASS'Y (SHOWN).  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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